Suip 2 nov

Work Orde October-24-12				*92					Page	1			
Item ID: Revision ID:	D206-781-0	53		Accept	*N900	040	100)*	Setup	Start		S1*	
Item Name:	Floor Protecto	or (Pilot, Co-Pilot and Pa	assenger)							Stop	*N:	S2*	
Start Date:	10/24/12	Start Qty: 1.00	*1*		Cust Item I	D:							
Required Date:	11/09/12	Req'd Qty: 1.00	*1*		Customer:								
Reference:									_	.			
Approvals:	Process Pla	an: MUS	Date: 12-10-2	√ Tooling:	Da	ıte:			Run	Start	*N	R1*	
				1	D:	nte:				Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours		Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr		Q	4 5								
DSI 9480	Α		\sim	e.									•
100			4)	0.00	19110)								
100		Memo	2	0.00	e					ML:	5 12-	11-01	-
Document Control			oluefile &type labels per PP	PP D206-781-053/ DS	19480							4	
110		Pick Kit		0.00						ذ	1 /	/)	
110 Packaging Packaging		Memo		0.00						121	/ _{]]} / _[.	2/2	-
120		QC4- 100% Inspect kits	for completeness	0.00	∜ 5								
120 QC Quality Control		Мето		0.00	.e9 1-0}					· · · · · · · · · · · · · · · · · · ·			-

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Crosstube Water Jet Engineering Rework Skid-tube Machining Small Fab Prod. Eng. Coor. Quality Part No. Scrap Rec/Store/Packaging Other Finishing Thermoforming Use-as-is Supplier Large Fab Composite Work Order Update NCR No. Description of work order update Action Sign & Initial Root Chief Eng Date Verification QC Inspector or Non-conformance Description Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Crushed/Crimped. Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 92155 October-24-12 10:18:03 AM				*921	55*							Page 2
Item ID: Revision ID: Item Name:	D206-781-	053 tor (Pilot, Co-Pilot and Pa	ssenger)	Accept	*N900	040	100)*	Setup	Start Stop		S1*
Start Date: Required Date: Reference:	10/24/12 11/09/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging)	Operation Description Memo		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp
Packaging		Identify and Location:PPP rev:	pack for shipping as per	PPP D206-781-053/ DSI 94	480						,	1 10

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

*14**0***

Quality Control

12/11/2 H

NCR:	⁄es	/ No	,			WORK ORDER NON-	100	NFORM	MANCE / UPDATE		·		_			
											QA Closed:	Da	ate:			
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
WOIR OIG	=1.					Rework			Skid-tube Crosstul	ре]	Water Jet		Engineering		
Part !	۱o. ₋					Scrap		·	Machining Small F		-	d. Eng. Coor.	_	Quality Other		
NCR No.						Use-as-is Work Order Update]		noforming Finishi Large Fab Composi		Rec/Stor	e/Packaging Supplie	-	Other		
Root					Descri	ption of work order update	1	nitial	Action		Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	<u>n (</u>	QC Inspector		
Doc/Data																
Equip/Tooling	Ш												ĺ			
Operator		•														
Material	igsqcup															
Setup	Щ	- '											1			
Other	Щ		ĺ													
Process	Н															
Supplier	\square		İ	•												
Training	Н						1									
Unapproved							ΔΠ	T CATE	GORY		<u> </u>	<u> </u>				
Landi	ng G	iear				General										
	_	Bending				Bend		Grain			Ovalized			Pressure/Forced		
	\vdash	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure		
	$\boldsymbol{\vdash}$	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld		
	П	Crushed/	Crimped	,		Burrs		4	ions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled		
	_	Cuffs	•			Contamination		Mainte	enance		Part Moved					
	П	Heat Trea	ət			Countersink		Mislabe	eled		Positioned \	V rong				
	П	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge		Other		
	П	Ripples in	n Bend			Drill Holes		Offset								
	П	Torque Waves in Extrusion				Drawing		Out of Calibration								

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

92155

Parent Item:

•

D206-781-053

Parent Item Name:

Floor Protector (Pilot, Co-Pilot and Passenger)

Start Date: 10/24/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC

		•											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-781-011 Floor Protector (Pilot and	Co-Pilot)	Manufactured	No			110	Each	3.0000	1	1		SI	
Troot Protector (1 not and	CO-1 noty			Location		Loc Oty	Lo	c Code					
				FG011		3							
				883 892		1			1				
D206-781-023 Floor Protector (Passenger	r Cabin)	Manufactured	No			110	Each	2.0000	1	1	9:	142	25
, 0	,			Location		Loc Qty	Lo	c Code				Bull	,
				FG		1						191111/	
				882	243	1							
				FG040		1							
				850)31	1							

NCR: Y	'es / No				WORK ORDER NON-C	CON	IFORM	MANCE / UPI						
										QA Closed:	Date:	· · ·		
Work Orde	er:				DISPOSITION	i	AGAINST DEPARTMENT/PROCESS							
					Rework	Skid-tube Crosstube				Water Jet	Engineering			
Part N	١٥.				Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is]	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR N	lo				Work Order Update	┇		Large Fab	Composite		Supplier			
Root]		Descri	ption of work order update	lı	nitial	Act	tion	Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling														
Operator						•		:						
Material	```				•	1								
Setup	· ·													
Other														
Process														
Supplier	_					1 '								
Training				•										
Unapproved						ALIL	T CATE	CORV				<u></u>		
Landi	ng Gear		···········		r General	AUL	CATE	GORT						
Lanui	Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre No	nt Conce	ntric to (_{2/5}	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	Cracks	or conce		,, <u> </u>	Broken/Damaged	\vdash		ion Incomplete		Part Incorre		Weld		
	Crushed/	Crimped		-	Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/M	-	Wrong Stock Pulled		
	Cuffs				Contamination	\vdash	Mainte	•		Part Moved	·	1		
	Heat Trea	at			Countersink	П	Mislabe	eled		Positioned V	Vrong			
	Inspectio	n Strip in	Tube		Cut Too Short	П	Misread	Ė		Power Loss/	Surge	Other		
	Ripples in	Bend			Drill Holes	П	Offset			•				
	Torque W	aves in E	Extrusion	, <u> </u>	Drawing		Out of Calibration							
	Turning Sequence				Finish		Out of Sequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D407-781 REV. C

REF CANADIAN STC: SH08-60 FAA STC: SR02726NY EASA STC: EASA.IM.R.S.01541

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO FACILITATE ORDERING OF A COMPLETE SET OF FLOOR PROTECTORS (PILOT, COPILOT AND PASSENGER CABIN) AS 1 COMBINED KIT INSTEAD OF 2 SEPERATE KITS. THIS IS ACCOMPLISHED BY ADDING THE D206-781-051 KIT TO SÉCTION 5.1 OF IIN-D407-781 FOR 206 A/B MODELS, THE D206-781-053 KIT TO SECTIONS 5.2 AND 5.3 OF IIN-D407-781 FOR 206 L/L1/L3/L4 MODELS AND THE D407-781-055 KIT TO SECTION 5.4 OF IIN-D407-781 FOR 407 MODELS AS SHOWN BELOW:

BELL 206 A/B

ADD:

FLOOR PROTECTOR KIT-PILOT, CO-PILOT PASSENGER CABIN

QTY -051	PART NUMBER	DESCRIPTION
Х	D206-781-051	FLOOR PROTECTOR KIT- PILOT, CO-PILOT & PASSENGER CABIN
1	D206-781-011	FLOOR PROTECTOR KIT (PILOT AND CO-PILOT)
1	D206-781-021	FLOOR PROTECTOR KIT (PASSENGER CABIN)

BELL 206 L/L1 5.2

BELL 206 L3/L4 5.3

ADD:

FLOOR PROTECTOR KIT- PILOT, CO-PILOT PASSENGER CABIN

OTY /053	PART NUMBER	DESCRIPTION
х	D206-781-053	FLOOR PROTECTOR KIT- PILOT, CO-PILOT & PASSENGER CABIN
1	, xD206 ±7:8 ≈1≥011 1	
1==	::D206=781=023=	FLOOR PROTECTOR KIT (PASSENGER CABIN)

5.4 **BELL 407**

ADD:

FLOOR PROTECTOR KIT- PILOT, CO-PILOT PASSENGER CABIN

QTY -055	PART NUMBER	DESCRIPTION
Х	D407-781-055	FLOOR PROTECTOR KIT- PILOT, CO-PILOT & PASSENGER CABIN
1	D206-781-011	FLOOR PROTECTOR KIT (PILOT AND CO-PILOT)
1	D407-781-025	FLOOR PROTECTOR KIT (PASSENGER CABIN)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

D. SHEPHE

DATE: 09.09.15 CERT. NO.: SH08-60 ISSUE NO .: .

Α	NEW IS:	SUE		AJ\$	09.09.15							
REV.			DESCRIPTION	BY	DATE							
DESIGN	SLA V		DART AEROS	DART AEROSPACE LTD								
DRAWN		AUS	HAWKESBURY, ON									
CHECKED			DRAWING NO.		REV. A							
MFG. AF	PPR.	N/A	DSI 9480	5	SHEET 1 OF 1							
APPRO\	VED	· AM	TITLE		SCALE							
DE APPR.		-4	ADDITIONAL KITS		NTS							
DATE	09.09).15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WINDLESS OF THE PRIVATE OF THE PROPERTY OF THE PROPERTY OF THE PRIVATE OF THE PRIVAT									

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